

BLUE

Dart Aerospace Ltd.

23

Date: Wednesday, 5/16/2007 8:14:46 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 32385
Estimate Number : 10937
P.O. Number : N/A
This Issue : 5/16/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : MACHINED PARTS
Previous Run : 30483
Written By :
Checked & Approved By : J. F. 07.05.16
Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC
Est Rev: C As per Rev C 07-03-19 JLM

Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER REVIEW
Part Number : D29392
Drawing Number : D2939 REV C
Project Number : N/A
Drawing Revision : C
Material : N/A
Due Date : 6/6/2007 Qty: 16 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D6101001 7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)
Issue material from stock: 7075-T7351 (QQ-A-250/12)
Cut Size 2.0" x 6.25" X 6.00" Grain Along 6.00" Length
Batch No: B.25345 J.F. 07/05/24

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Program part number and batch number.
1-Inspect part number and batch number are programmed correctly.
2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet
3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet
4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet
5-Deburr J.F. 07/25/25 J.L. 07/05/27 (16)

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet E. 07/06/07 (16)

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET J.F. 07/06/07 (16)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER
REVIEW

Job Number: 32385

Part Number: D29392

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 07/06/09 16

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

41 07-06-11 16

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

-PRIME

-PAINT DELFLEET BLUE (PER QSI005)

-CLEAR DELFLEET

*4102
R/O: 40586 107102108 ②*

PTC

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

07-07-09 ①

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/7/11 ①

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07-07-12 ①

Job Completion



07-07-12

DART AEROSPACE LTD	Work Order:	32385
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.116"	.116"	.114	.116		
B	0.100	0.140		.114"	.114"	.113	.115		
C	0.100	0.140		.117"	.117"	.117	.115		
D	0.210	0.230		.222"	.222"	.219	.219		
E	1.245	1.255		1.250"	1.250"	1.250	1.250		
F	1.245	1.255		1.250"	1.250"	1.250	1.250		
G	2.495	2.505		2.502"	2.501"	2.500	2.500		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.572	1.582		1.580"	1.580"	1.577	1.577		
J	2.495	2.505		2.500"	2.500"	2.500	2.500		
K	0.257	0.262		Ø.257"	Ø.257"	Ø.257"	Ø.257"		
L	0.312	0.317		Ø.312"	Ø.312"	Ø.312"	Ø.312"		
M	0.235	0.240		Ø.239	Ø.239	Ø.239	Ø.239		
N	0.100	0.140		.120"	.120"	.118	.118		
O	0.540	0.560		.550"	.552"	.551	.550		
P	0.490	0.510		.503"	.503"	.501	.498		
Q	3.715	3.725		3.721"	3.721"	3.720	3.720		
R	2.720	2.760		2.745"	2.745"	2.745	2.745		
S	0.240	0.270		.253"	.253"	.247	.250		
T	0.100	0.180		.140"	.140"	.140"	.140"		
U	1.625	1.635		1.630"	1.630"	1.630	1.630		
V	1.362	1.372		1.368"	1.368"	1.367	1.367		
W	0.316	0.321		Ø.318"	Ø.318"	Ø.318	Ø.318		
X	1.250	1.270		1.260"	1.259"	1.259"	1.260"		
Y	1.565	1.585	DT8695 A/B	1.575"	1.575"	1.575"	1.575"		
Z	0.178	0.198		R.188"	R.188"	R.188"	R.188"		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.F. / J.L.	Audited by: gml
Date: 07/05/25 / 07/05/26 / 07/06/07	Date: 07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	32385
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.115	.115	.118	.115		
B	0.100	0.140		.115	.115	.116	.115		
C	0.100	0.140		.118	.121	.120	.116		
D	0.210	0.230		.219	.218	.219	.219		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.315	.315	.315	.315		
M	0.235	0.240		0.239	.239	.239	.239		
N	0.100	0.140		.117	.117	.116	.119		
O	0.540	0.560		.550	.550	.551	.549		
P	0.490	0.510		.501	.501	.500	.498		
Q	3.715	3.725		3.719	3.720	3.720	3.720		
R	2.720	2.760		2.745	2.745	2.745	2.745		
S	0.240	0.270		.250	.250	.249	.249		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.250	1.270		1.260	1.258	1.260	1.262		
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.575	1.576		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.L.
Date: 07/05/26 / 07/06/07

Audited by: gml
Date: 07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 32385
Description: 206 Saddle, Inboard, Right side	Part Number: D2939-2
Inspection Dwg: D2939 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.119	.118	.118	.118		
B	0.100	0.140		.119	.117	.117	.118		
C	0.100	0.140		.120	.120	.120	.120		
D	0.210	0.230		.218	.219	.220	.218		
E	1.245	1.255		1.250	1.250	1.249	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.499	2.500	2.499		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.315	.315	.315	.315		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.119	.119	.119	.117		
O	0.540	0.560		.550	.551	.551	.550		
P	0.490	0.510		.501	.501	.502	.501		
Q	3.715	3.725		3.719	3.719	3.720	3.720		
R	2.720	2.760		2.745	2.745	2.745	2.745		
S	0.240	0.270		.249	.248	.250	.248		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.250	1.270		1.262	1.261	1.260	1.261		
Y	1.565	1.585	DT8695 A/B	1.576	1.576	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.L.	Audited by: J.M.
Date: 07/05/26 / 07/06/07	Date: 07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 32385
Description: 206 Saddle, Inboard, Right side	Part Number: D2939-2
Inspection Dwg: D2939 Rev. C	Page 1 of 1

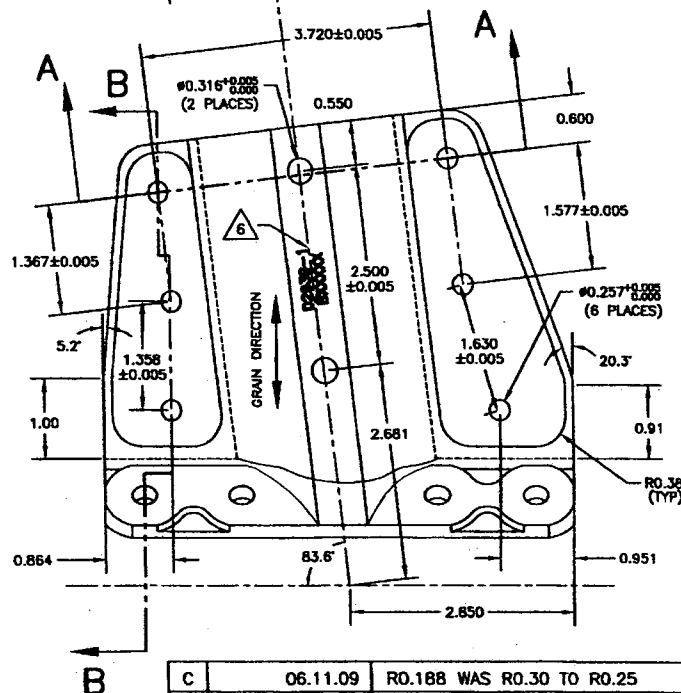
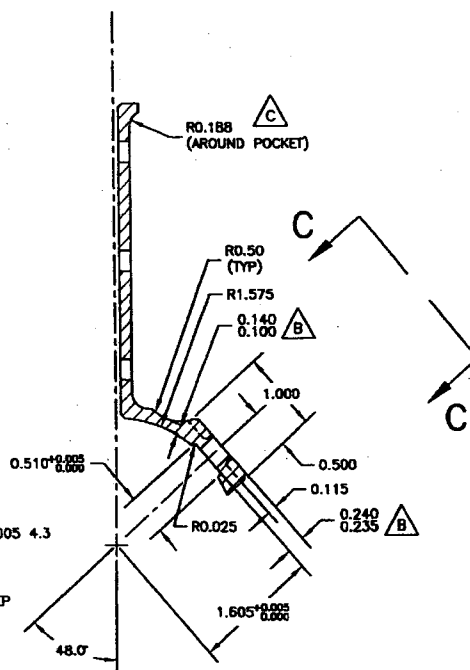
Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:



				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.119	.126	.120	.120		
B	0.100	0.140		.119	.120	.119	.120		
C	0.100	0.140		.120	.118	.120	.120		
D	0.210	0.230		.219	.219	.220	.219		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.249	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
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K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.315	.315	.315	.315		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.118	.118	.119	.120		
O	0.540	0.560		.549	.550	.548	.548		
P	0.490	0.510		.502	.500	.501	.500		
Q	3.715	3.725		3.719	3.720	3.720	3.720		
R	2.720	2.760		2.745	2.745	2.745	2.745		
S	0.240	0.270		.250	.250	.249	.249		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.250	1.270		1.261	1.260	1.260	1.262		
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.575	1.576		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.L.
Date: 07/05/27 / 07/06/09

Audited by: [Signature]
Date: 07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	[Signature]



C	06.11.09	RO.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	 DART AEROSPACE USA, INC. BELLFLORE, TN
4	CB	
CHECKED	APPROVED	DRAWING NO.
PH		D2939
DATE		TITLE
06.11.09		SADDLE INSIDE
		SCALE
		2:

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THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (Q0-A-250/12)
(MAKE FROM 06101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 22385

01.02.12 ~~df~~